

Date: Monday, 11/05/2009 1:22:26 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARPLATE
<b>Job Number</b> : 47862	
<b>Estimate Number</b> : 12403	
<b>P.O. Number</b> :	<b>Part Number</b> : D3511041 <b>BK</b>
<b>This Issue</b> : 11/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3511 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 46882	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 05/06/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 09 05 11</u>	
<b>Comment</b> : Est Rev:A New Issue 06-05-04 JLM	
Est Rev:B New process 06-05-05 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S188	304 SHEET 0.188
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**Comment:** Qty.: 1.5572 sf(s)/Unit Total : 6.2286 sf(s)  
 304 SHEET .188" THICK  
 (M304S0188)  
 Batch: 107676 B 9-5-01

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3511  
 Dwg Rev: A  
 Prog Rev: A

B 9-5-01

(4)

2-Deburr if necessary B 9-5-01

Identify as D3511-1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 9-5-01

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5/05/09 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 11/05/2009 1:22:26 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 47862

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35031

Cup



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

CUP

Batch:

B 47461 x 29

3 x B47911

SP 09.05.29

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend fwd 90 deg. bend per dwg D3511

SB 09/05/25

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/05/25

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3511

A/R SS ROD Batch:

M108775

SP 09.06.01

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3511

SB 09/06/01

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SP 09.06.01

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/06/01

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

7:35

FL 09/06/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 11/05/2009 1:22:26 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 47862

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 320°  
FINISH TIME: 8:05

*Fxl* 09/06/03 (4)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BF* 09-06-3 (A)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*9/6/4*

*SP*

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/05 *af*

Job Completion



*mf*  
09-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

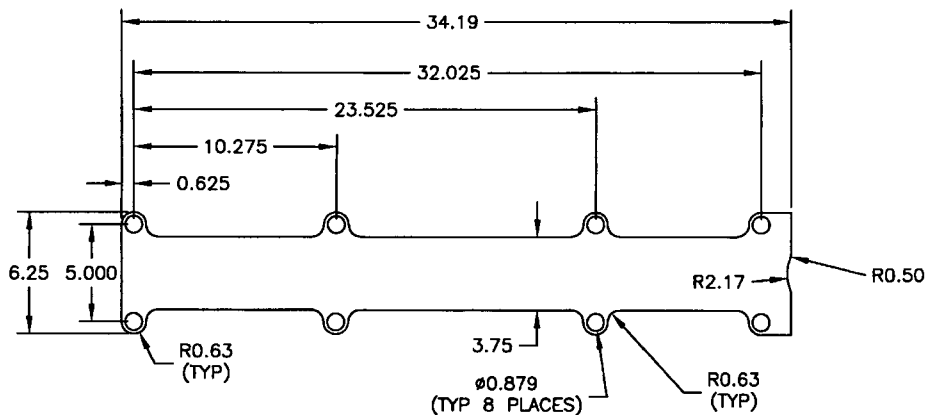
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

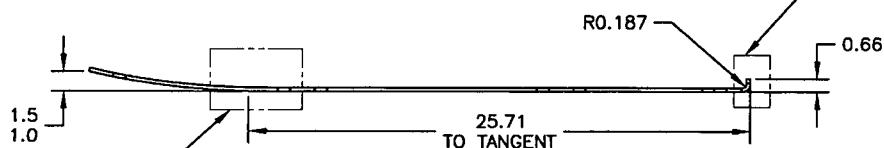
**NOTE:** Date & initial all entries





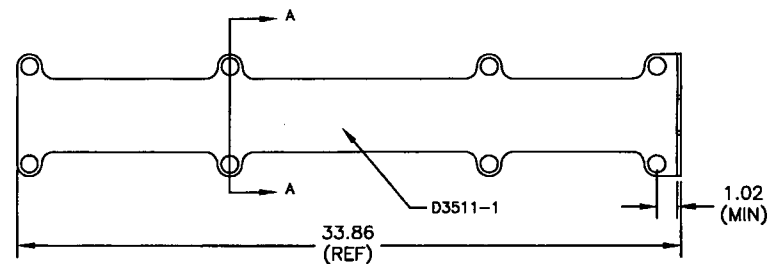
**D3511-1F FLAT PATTERN**

NOTE: BEND BEFORE WELDING

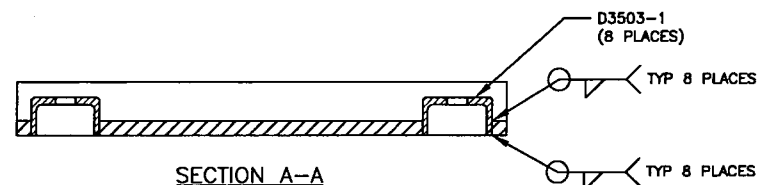


**D3511-1 BEND DETAIL**

NOTE: BEND AFTER WELDING



**D3511-041 WELD DETAIL**



**D3511-041 WEARPLATE ASSEMBLY**

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)  
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3511-041 WEARPLATE ASSEMBLY PARTS LIST**

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
1	D3503-1	CUP

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A	06.04.04	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED JH	APPROVED JH	DRAWING NO. D3511
DATE 06.04.04	TITLE WEARPLATE	REV. A SHEET 1 OF 1 SCALE NTS

RELEASED

06 04 25

NO. 17886  
WITHOUT NOTICE  
WORK ORDER  
RETURN TO  
ENGINEERING  
FOR CONTROLLED COPY  
SUBJECT TO AMENDMENT  
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